

Split

Ship Oct 20

Work Order ID 150848-2

150848

Page 1

Thursday, September 08, 2016 10:03:07 AM

Item ID: D4526-042

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Maintenance Step Assembly

Start Date: 9/9/2016

Start Qty: ~~6.00~~

6

Cust Item ID:

Required Date: 10/19/2016

Req'd Qty: 6.00

6

Customer:

Reference:

Run Start

NR1

Approvals: Process Plan: dmDate: 16/09/08

Tooling:

Date:

Stop

NR2

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4526	A								
100	Pick Kit	0.00							
100									
Packaging	Memo	0.00							
Packaging									
110		0.00							
110									
Small Fab	Memo	0.40							
Small Fab	Assemble as per Dwg Torque screws up to 15-25 in- lbs								
120	QC5- Inspect part completeness to step on W/O	0.00							
120									
QC	Memo	0.02							
Quality Control									

6 SEP 09 2016

3x

16/09/21 DAS 36 9-89

x3

v12

DAS 16 9-89

16/09/22

Work Order ID 150848***150848***

Page 2

Thursday, September 08, 2016 10:03:07 AM

Item ID: D4526-042

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Maintenance Step Assembly

Start Date: 9/9/2016 Start Qty: 6.00

6

Cust Item ID:

Required Date: 10/19/2016 Req'd Qty: 6.00

6

Customer:

Reference:

Run Start

NR1

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop

NR2

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

Identify as per dwg & Stock Location: ST

0.00

130

Packaging

Memo

0.01

Packaging

SEP 22 2016

DAS
6
9-89

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.10

Quality Control

DAS
21
9-89

SEP 22 2016

DAS
21
9-89

SEP 22 2016

Picklist Print

Page 1

Thursday, September 08, 2016 10:03:06 AM

Work Order ID: 150848

150848

Parent Item: D4526-042

D4526-042

Parent Item Name: Maintenance Step Assembly

Start Date: 9/9/2016

Required Date: 10/19/2016

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP REV:A 11.11.28 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4092-1		Manufactured	No			100	Each	25.0000	2	12			
D4092-1									**				
Maintenance Step													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST450				25					
				141433				1					
				144611				16					
				150169				8					
D4526-043		Manufactured	No			100	Each	7.0000	1	6			
D4526-043									**				
Tube Assembly													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST255				7					
				142603				3					
				143377				4					
D4527-1		Manufactured	No			100	Each	3.0000	1	6			
D4527-1									**				
Bracket													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST449				3					
				139068				1					
				143481				2					

DAS
36
9-89

SEP 09 2016

150851 (3X)

Picklist Print

Page 2

Thursday, September 08, 2016 10:03:06 AM

Work Order ID: 150848

150848

Parent Item: D4526-042

D4526-042

Parent Item Name: Maintenance Step Assembly

Start Date: 9/9/2016

Required Date: 10/19/2016

Start Qty: 6.00

Required Qty: 6.00

D4527-3

Manufactured No

100

Each

7.0000

1

6

D4527-3

Bracket

Location

Loc Qty

Loc Code

ST449

7

141787

1

143436

6

100

Each

1,649.000

10

60

MS21042L3

Purchased

No

MS21042L3

Nut

Location

Loc Qty

Loc Code

FP001

14

m133790

14

GA

278

m134360

112

m135135

166

OVER007

600

m135530

600

ST303

757

m135135

157

m135407

600

100

Each

195.0000

8

48

MS24694-S55

Purchased

No

MS24694-S55

Screw

Location

Loc Qty

Loc Code

ST283

195

m134376

95

m135408

100

SEP 09 2016

Picklist Print

Page 3

Thursday, September 08, 2016 10:03:06 AM

Work Order ID: 150848

150848

Parent Item: D4526-042

D4526-042

Parent Item Name: Maintenance Step Assembly

Start Date: 9/9/2016

Required Date: 10/19/2016

Start Qty: 6.00

Required Qty: 6.00

MS24694-S75

Purchased

No

100

Each

75.0000

2

12

DAS
G
ABC

MS24694-S75

Screw

Location

Loc Qty

Loc Code

GA

71

M128402

71

ST283

4

121415

4

100

Each

1,494.000

10

60

DAS
G
ABC

NAS1149D0332J

Purchased

No

NAS1149D0332.J

Washer

Location

Loc Qty

Loc Code

CA

6

m129682

6

FP001

506

m134848

506

ST260a

600

m135566

600

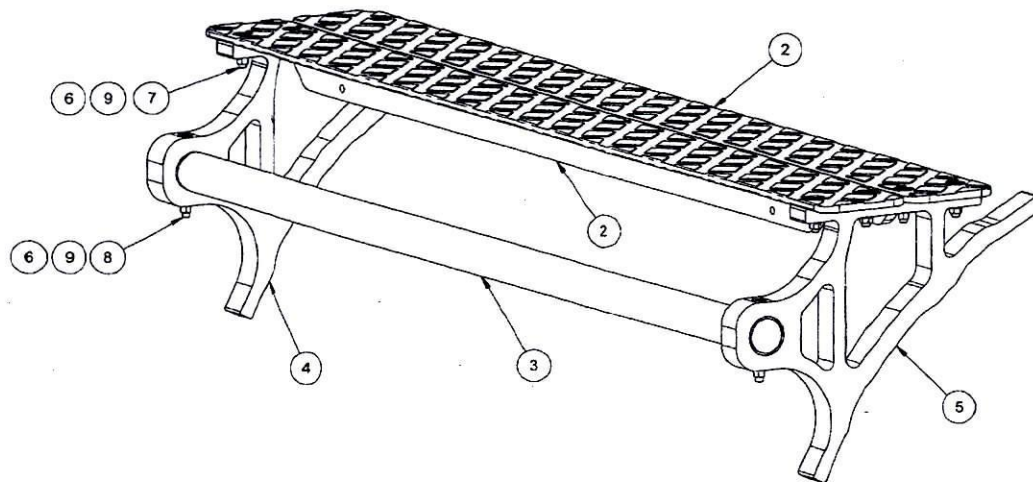
ST264

382

m135536

382

SEP 09 2016



D4526-042 MAINTENANCE STEP ASSEMBLY

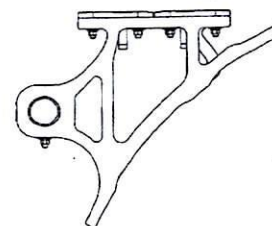
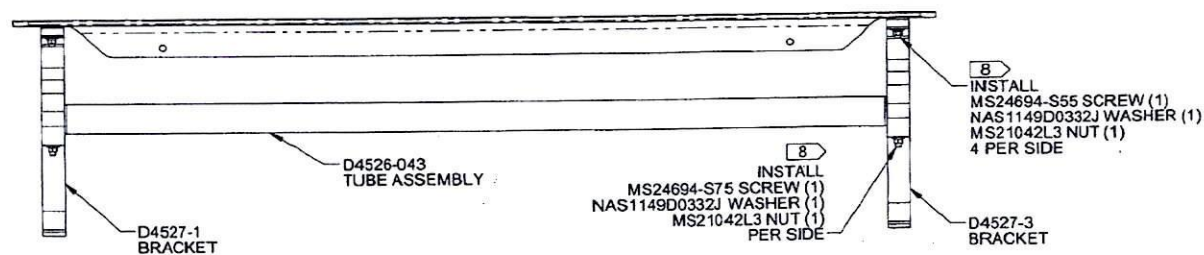
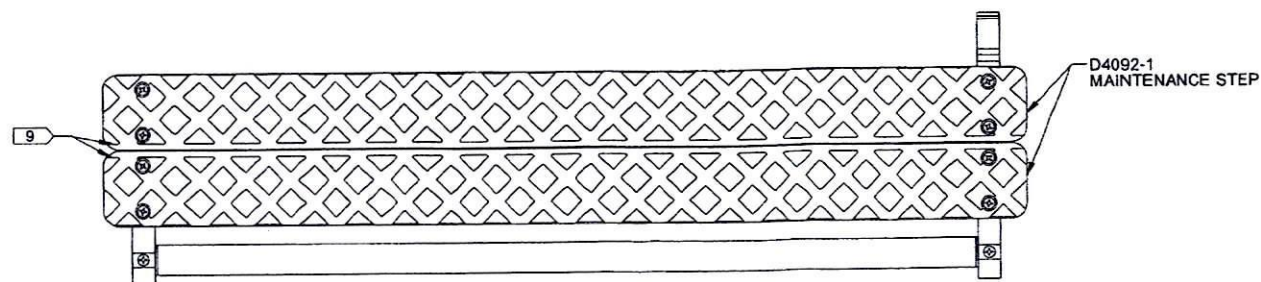
ITEM	QTY	PART NUMBER	DESCRIPTION
1	X	D4526-042	MAINTENANCE STEP ASSEMBLY
2	2	D4092-1	MAINTENANCE STEP
3	1	D4526-043	TUBE ASSEMBLY
4	1	D4527-1	BRACKET
5	1	D4527-3	BRACKET
6	10	MS21042L3	NUT
7	8	MS24694-S55	SCREW
8	2	MS24694-S75	SCREW
9	10	NAS1149D0332J	WASHER

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 150843

2m 16/09/08

RELEASED
2011-11-28

A	NEW ISSUE	RF	11.11.22
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	RF	KENT, WA	
CHECKED	RF	DRAWING NO.	REV. A
MFG. APPR.	RF	D4526	SHEET 1 OF 5
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	MAINTENANCE STEP ASSY	NTS
DATE	11.11.22	COPYRIGHT © 2011 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	



D4526-042 MAINTENANCE STEP ASSEMBLY

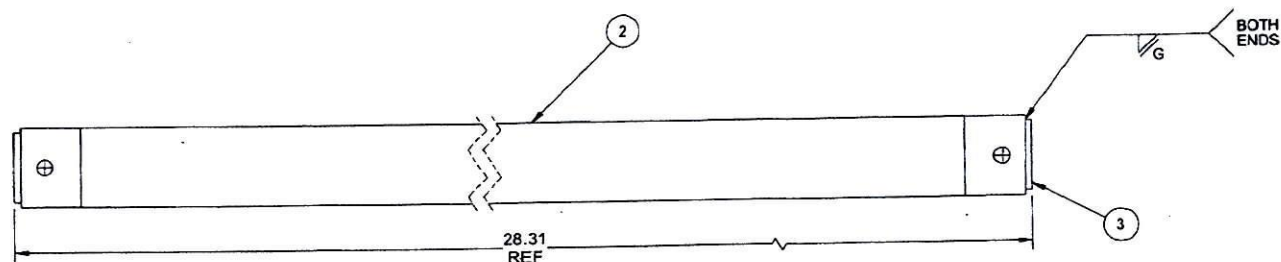
RELEASED
2011-11-28

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: PER QSI 044 6.1
- 7) WEIGHT: 7.09 lbs
- 8) TORQUE SCREWS UP TO 15-25 in-lb (1.7-2.8 N-m)
- 9) GRIP CUTOUT TOWARD CENTER

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DRAWN	RF	KENT, WA	
CHECKED	RF	DRAWING NO.	REV. A
MFG. APPR.	RF	D4526	SHEET 2 OF 5
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	MAINTENANCE STEP ASSY	
DATE	11.11.22	NTS	
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ITEM	QTY	PART NUMBER	DESCRIPTION
1	X	D4526-043	TUBE ASSEMBLY
2	1	D4526-1	TUBING
3	2	D4526-3	CAP



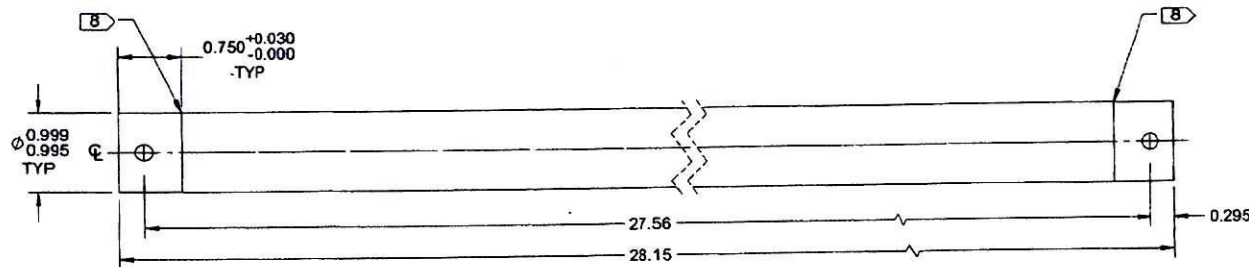
D4526-043 TUBE ASSEMBLY

RELEASED
2011-11-28

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: PER QSI 044 6.1
- 7) WEIGHT: 1.32 lbs
- 8) WELD PER QSI 004

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MFG. APPR.	<i>[Signature]</i>	D4526	SHEET 3 OF 5
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	MAINTENANCE STEP ASS'Y	NTS
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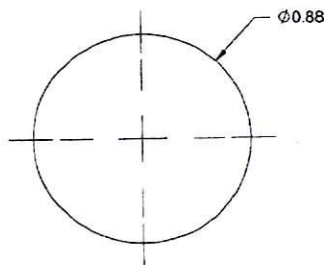
D4526-1 TUBING

RELEASED
2011-11-28

NOTES:

- 1) MATERIAL: 6061-T6 OR 6061-T62 TUBING
PER WW-T-700/6 OR AMS 4080 OR AMS 4082
OR QQ-A-200/8 OR QQ-A-225/8
REF DART SPEC M6061T6T1.000W.188
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.31 lbs
- 8) MIN RADIUS OF TRANSITION OF R0.06

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CHECKED				DRAWING NO.	REV. A
MFG. APPR.				D4526	SHEET 4 OF 5
APPROVED				TITLE	SCALE
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D4526-3 CAP

RELEASED
2011-11-28

NOTES:

- 1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM ROUND BAR
PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160) OR ASTM B211 OR ASTM B221
REF DART SPEC M6061T6R
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.005 lbs

DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	RF	KENT, WA	
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MFG. APPR.	<i>[Signature]</i>	D4526	SHEET 5 OF 5
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	MAINTENANCE STEP ASSY	NTS
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